

Date: Tuesday, 1/9/2007 4:06:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 30212
 Estimate Number : 10530
 P.O. Number : N/A Part Number : D2571
 This Issue : 1/9/2007 S.O. No. : N/A Drawing Number : D2571 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 30094 Material : N/A
 Due Date : 1/30/2007 Qty: 12 Um: Each
 Written By : JA
 Checked & Approved By : JA 07.01.09
 Comment : Est: 1 02/10/02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B05354

JA 07/01/22

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 30212 Double check by: JA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

JA 12.8 07/01/22 (12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

JA 12.8 07/01/22 (12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 12.8 07/01/22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial - Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/01/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX/

07/02/01

(12)

7.0

POWDER COATING

POWDER COATING



M103141



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R/48

07/02/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/02/06 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S472

07/02/06 (12x) C

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/07

Job Completion



U 07.02.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30212
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	Ø.440"	Ø.440"	Ø.440"		
B	1.745	1.755		1.750	1.749	1.749	1.750		
C	3.495	3.505		3.500	3.500"	3.501	3.500		
D	1.745	1.755		1.750	1.749"	1.749	1.750		
E	7.990	8.010		8.000	8.004"	8.002	7.995		
F	0.490	0.510		.500	.501"	.503	.505		
G	0.257	0.262	DT8683	.258	Ø.260"	Ø.260	Ø.260"		
H	0.375	0.380	DT8684	.375	Ø.376"	Ø.376"	Ø.376"		
I	0.490	0.510		.501	.505"	.506"	.505		
J	1.174	1.184		1.182	1.181"	1.181"	1.180		
K	0.558	0.578		.569	.570"	.570"	.570		
L	1.174	1.184		1.182	1.181"	1.181"	1.181		
M	1.490	1.500		1.496	1.499"	1.499"	1.499		
N	2.495	2.505		2.501	2.502"	2.502"	2.502		
O	3.869	3.879		3.875	3.877"	3.877"	3.877		
P	0.115	0.135		.124	.123"	.122"	.122		
Q	0.115	0.135		.128	.125"	.125"	.135		
R	0.240	0.260		.254	.251"	.149"	.149		
S	0.115	0.135		.121	.130"	.130"	.130		
T	0.178	0.198		.188	Ø.188"	Ø.188"	Ø.188		
U	2.940	2.980		2.960	2.963"	2.963"	2.963		
V	0.230	0.250		.240	.243"	.244"	.244		
W	0.115	0.135		.124	.123"	.125"	.125		
X	0.308	0.313		.312"	.312"	.310	.310		
Y	0.760	0.765		.764"	.764"	.764	.764		
Z	0.352	0.372		.372	.367"	.360	.360		
AA	0.470	0.530		.500	Ø.500"	Ø.500	Ø.500		
AB	0.615	0.635		.625"	.625"	.625	.625		
AC	0.053	0.073		.063	.063"	.063"	.063		
AD	0.240	0.260		.250	.249"	.249"	.249		
AE	1.375	1.395		1.386	1.388"	1.386"	1.387"		
AF	0.115	0.135		.125	.125"	.130"	.130		
AG	0.240	0.280		.252	.250"	.249	.249		
AH	0.240	0.260		.252	.251"	.251"	.251		
AI	2.000	2.020		2.001	2.000"	2.001"	2.002"		
AJ	0.023	0.043		.025	.025"	.025"	.025		

Accept/Reject

Measured by:	S.F. / J.F.
Date:	07/01/23

Audited by:	E
Date:	07/01/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30212
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.003	8.003		
F	0.490	0.510		.500	.506	.502	.499		
G	0.257	0.262	DT8683	.258	.259	.258	.258		
H	0.375	0.380	DT8684	.376	.375	.375	.375		
I	0.490	0.510		.508	.502	.507	.501		
J	1.174	1.184		1.180	1.180	1.178	1.178		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.872	3.872		
P	0.115	0.135		.122	.121	.121	.121		
Q	0.115	0.135		.128	.128	.121	.121		
R	0.240	0.260		.252	.250	.251	.251		
S	0.115	0.135		.134	.125	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.964	2.960	2.962	2.962		
V	0.230	0.250		.245	.240	.248	.248		
W	0.115	0.135		.128	.128	.126	.126		
X	0.308	0.313		.310	.312	.312	.312		
Y	0.760	0.765		.760	.764	.764	.764		
Z	0.352	0.372		.360	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.626	.627		
AC	0.053	0.073		.060	.060	.063	.063		
AD	0.240	0.260		.250	.250	.250	.248		
AE	1.375	1.395		1.385	1.385	1.386	1.385		
AF	0.115	0.135		.125	.125	.130	.130		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.253	.251		
AI	2.000	2.020		2.001	2.001	2.000	2.001		
AJ	0.023	0.043		.043	.043	.023	.023		
Accept/Reject									

Measured by:	J.F. / S.F.
Date:	07/01/27

Audited by:	En
Date:	07/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30212
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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500"	3.500"	3.500"	3.500"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.003"	8.003"	8.003"	8.003"		
F	0.490	0.510		0.501"	0.501"	0.501"	0.501"		
G	0.257	0.262	DT8683	0.260"	0.260"	0.260"	0.260"		
H	0.375	0.380	DT8684	0.376"	0.376"	0.376"	0.376"		
I	0.490	0.510		0.502"	0.502"	0.503"	0.503"		
J	1.174	1.184		1.180"	1.180"	1.180"	1.180"		
K	0.558	0.578		0.568"	0.570"	0.570"	0.570"		
L	1.174	1.184		1.179"	1.179"	1.179"	1.179"		
M	1.490	1.500		1.495"	1.495"	1.495"	1.495"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		0.123"	0.124"	0.123"	0.123"		
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.251"	0.251"	0.251"	0.250"		
S	0.115	0.135		0.130"	0.130"	0.130"	0.130"		
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
U	2.940	2.980		2.962"	2.962"	2.962"	2.962"		
V	0.230	0.250		0.246"	0.245"	0.244"	0.244"		
W	0.115	0.135		0.126"	0.127"	0.125"	0.130"		
X	0.308	0.313		0.312"	0.312"	0.312"	0.312"		
Y	0.760	0.765		0.764"	0.764"	0.764"	0.764"		
Z	0.352	0.372		0.367"	0.363"	0.363"	0.363"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.629"	0.627"	0.625"	0.625"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.252"	0.255"	0.250"	0.250"		
AE	1.375	1.395		1.385"	1.385"	1.386"	1.386"		
AF	0.115	0.135		0.130"	0.130"	0.130"	0.130"		
AG	0.240	0.280		0.250"	0.250"	0.250"	0.250"		
AH	0.240	0.260		0.253"	0.255"	0.250"	0.251"		
AI	2.000	2.020		2.001"	2.001"	2.001"	2.000"		
AJ	0.023	0.043		0.023"	0.023"	0.023"	0.023"		
Accept/Reject									

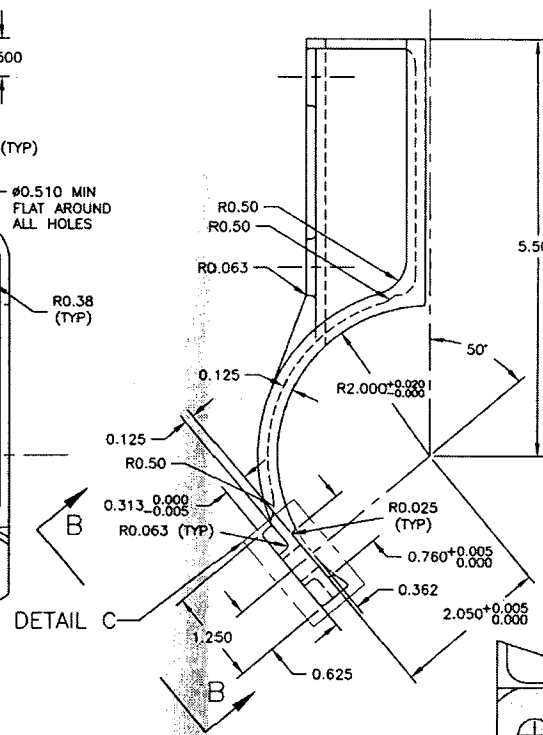
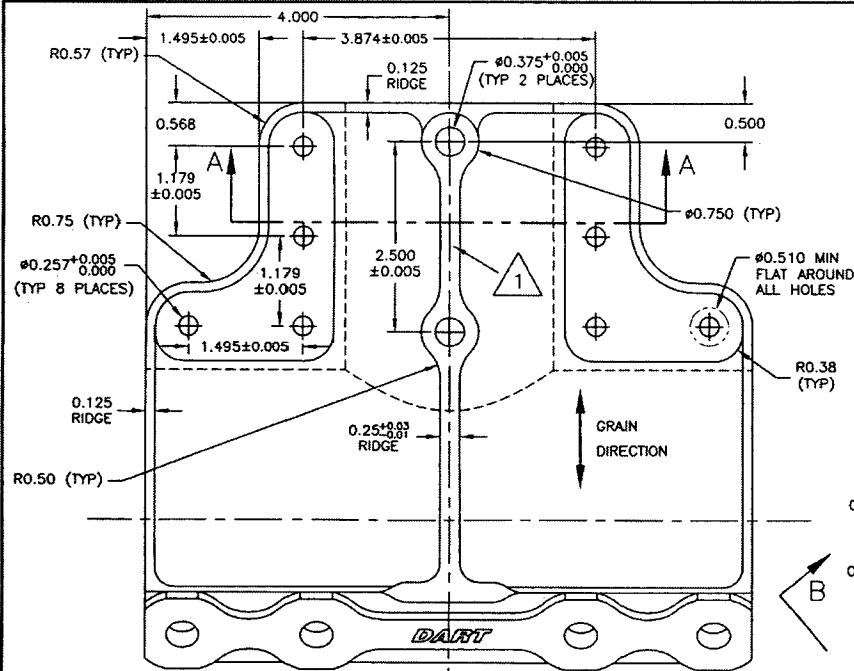
Measured by:	J.F. / J.F.
Date:	07/01/29

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Date:	07/01/29

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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05-12-06

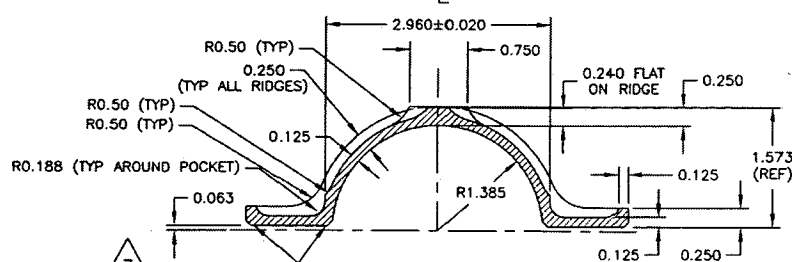


NOTES

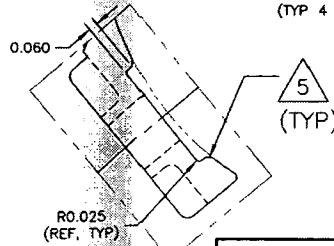
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

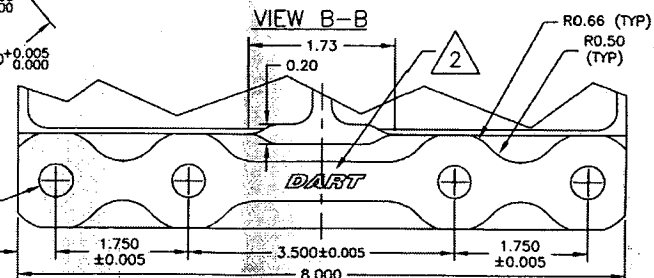
E



SECTION A-A



DETAIL C
SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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 MARKHAM, ONTARIO, CANADA

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